

Date: Friday, 2/23/2007 8:31:26 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPLATE		
Job Number	30879					
Estimate Number	10299					
P.O. Number	N/A		Part Number	D25775		
This Issue	2/23/2007	S.O. No.	S.O. No.	D2577 REV E		
Prsht Rev.	NC		Project Number	N/A		
First Issue	N/A		Drawing Revision	E		
Previous Run	30812		Material	N/A		
Written By			Due Date	3/24/2007		
Checked & Approved By			Qty:	20	Um:	Each
Comment	Est: F 02.09.24 Re-format KJ/RF Est Rev:D Now on Waterjet 06-06-14 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
Comment: Qty.: 1.0301 sf(s)/Unit Total : 20.6010 sf(s) 1010/1025 16GA SHEET (m1010s16ga) Batch: 103788 ml 070316 20		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2577 Dwg Rev: E ml 070316 20 Prog Rev: E		
2-Deburr if necessary SAD 07103124 20		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE.
Comment: DIMENSIONAL CHECK ml 070316 20 Inspect dimensions per template D2577-5T1		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK M8 07/03/24 20		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr SAD 07/03/24 20		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30879

Part Number: D25775

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

SD 07/03/24 20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA 07/03/24 20

8.0

POWDER COATING

POWDER COATING



M101601



20X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h

07/03/26

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 07/03/26 20

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

a.m

07/03/26

(20)

(20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/26

Job Completion



U 07/03/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30879
Description: Wearshoe	Part Number:	D2577-5
Inspection Dwg: D2577	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

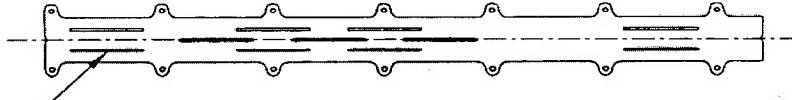
Measured by:	M. M
Date:	07.03.16

Audited by:	M.S
Date:	07/03/24

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.12.07	New Issue	KJ/JLM	RE

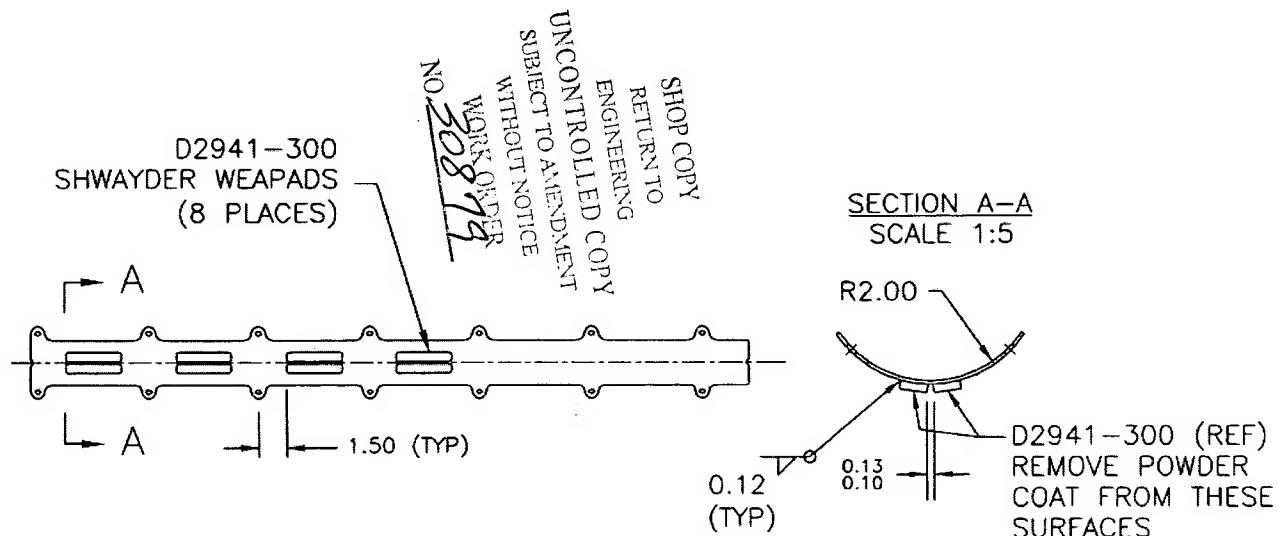
7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

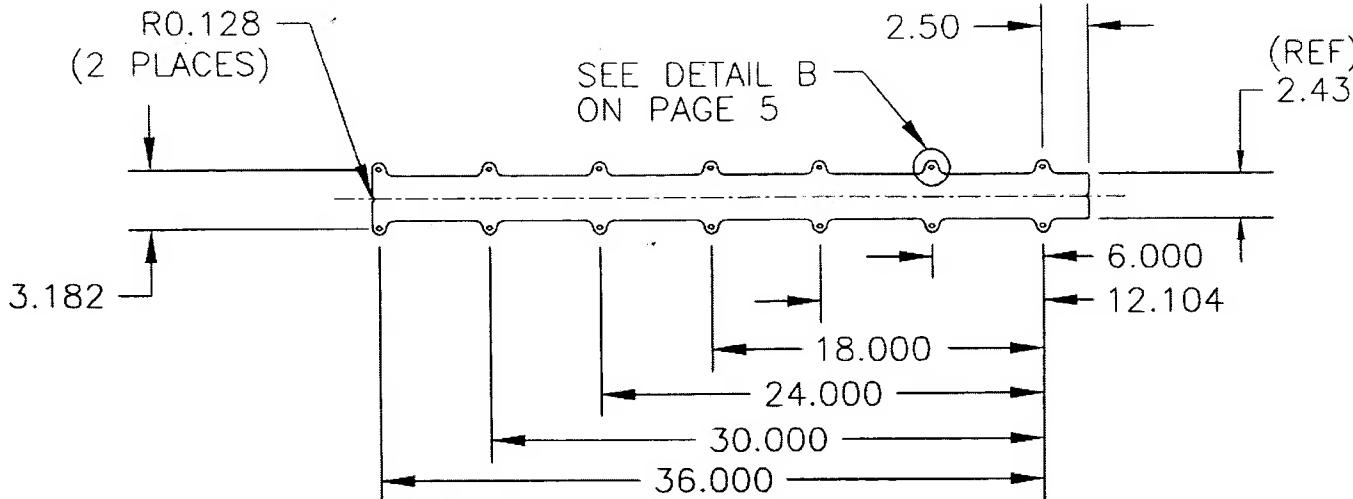
DART

GACO
DRAFT

RELEASED

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	CP	HAWKESBURY, ONTARIO, CANADA
DATE	APPROVED	DRAWING NO.
00.09.22		D2577
A	96.09.16	NEW ISSUE
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO OBOUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176

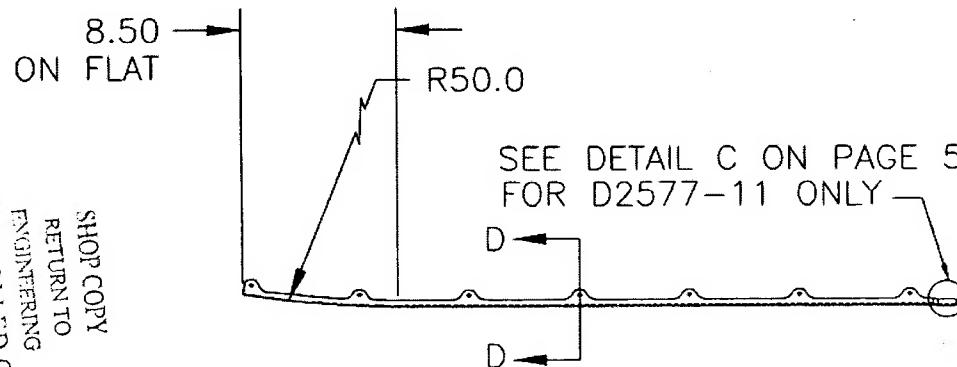


D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SHEET 1 OF 1

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09.09.26

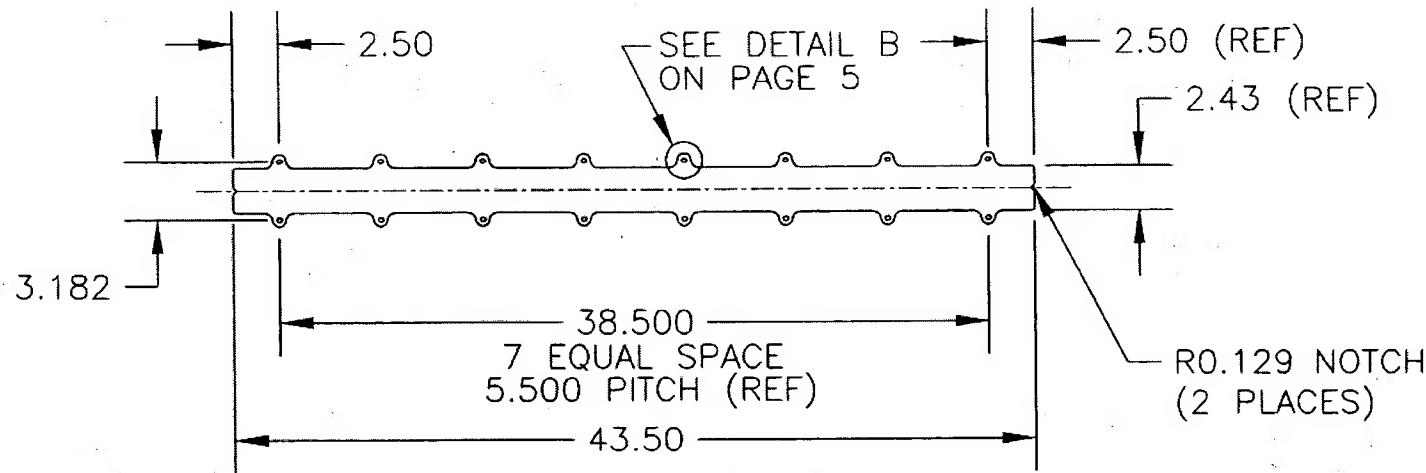
REV. E

SHEET 2 OF 5

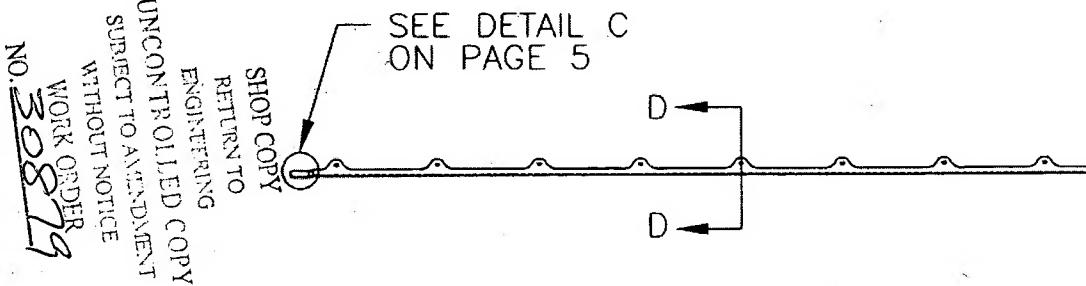
SCALE

1:10

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
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✓	✓	D2577
DATE		SHEET 3 OF 5
00.09.22		SCALE
		1:10
		WEARSHOE

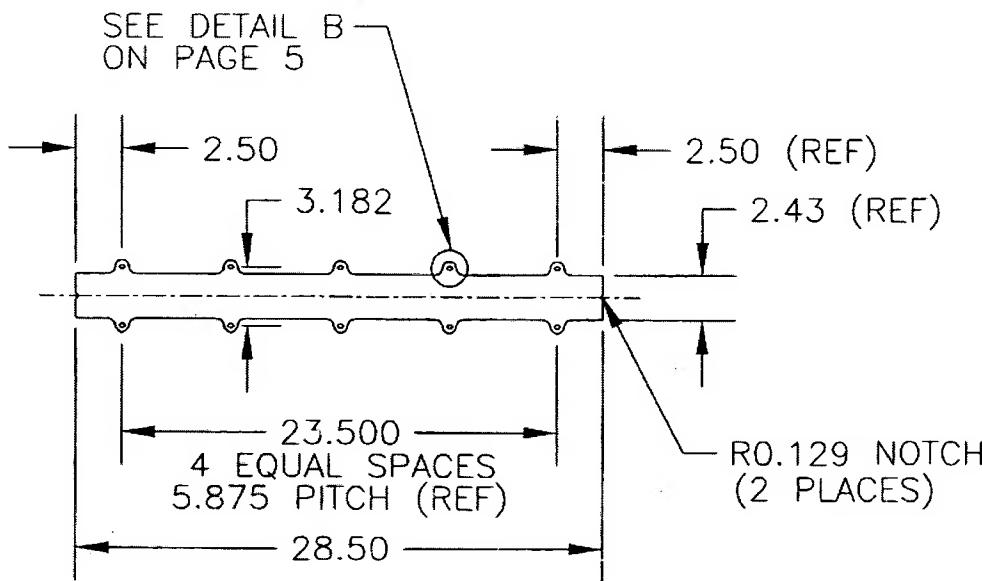
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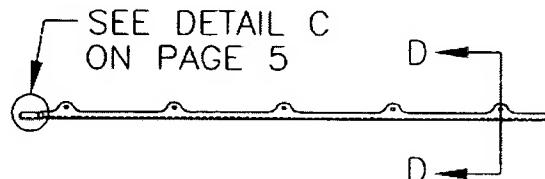


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D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
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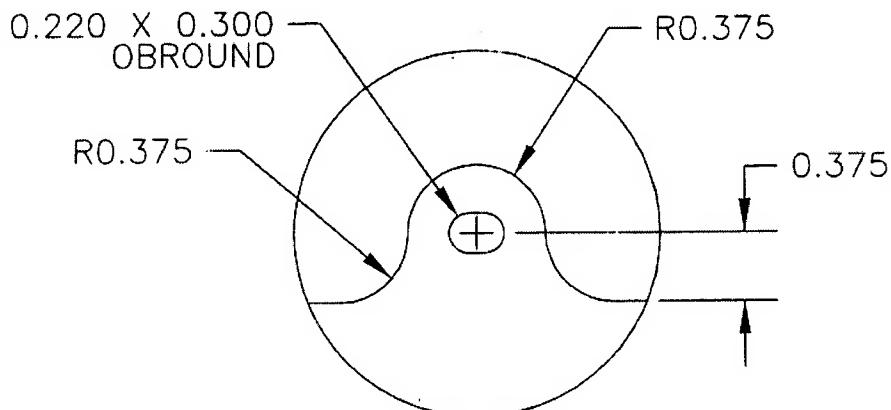
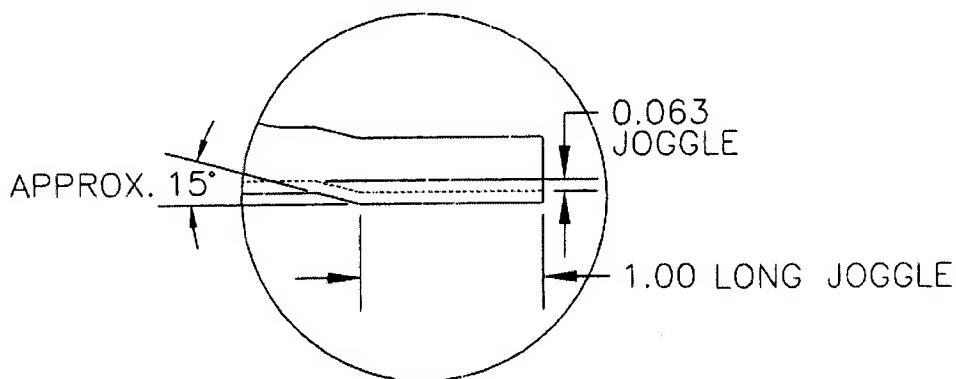
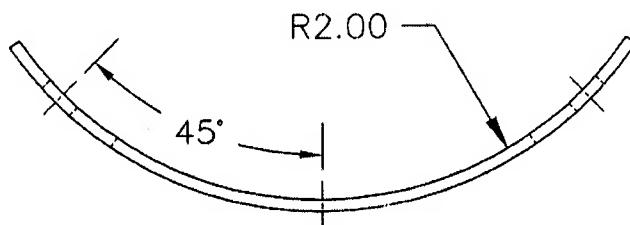
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00 09.26 40

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DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

DETAIL B (SCALE 1:1)**RELEASED**
00.09.26 *[Signature]*DETAIL C (SCALE 1:1)SECTION D-D (SCALE 1:1)

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